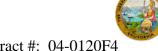
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453

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Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-006528 Address: 333 Burma Road **Date Inspected:** 20-Apr-2009

City: Oakland, CA 94607

OSM Arrival Time: 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: ZPMC and ABF **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component:** SAS tower

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance(QA) Inspector, Wai Pau, was present during the times noted above for observations relative to the work being performed.

Bay #11 East and West Tower Shop

East Tower Lift #1:- Caltrans QA Inspector observed ten ZPMC workers installed corner diagonal stiffeners on the skin plates A to E. The locations for installing corner diagonal stiffeners are from 9m to 47.6m. The SMAW tack welding has been applied on the corner diagonal stiffener joints after the fit up accepted by ZPMC and ABF QC. Based on Caltrans QAI observations, no discrepancies were noted.

West Tower Lift#2:- Caltrans QA Inspector observed four welder performed FCAW process on fit lug welds of diaphragm that connected skin plate C. The fit lug welds are located at elevation 53m to 80.7m diaphragm section. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

West Tower Lift#1:- Caltrans QA Inspector observed four welder performed FCAW process on diaphragm that connected skin plate C. The diaphragms are located at elevation 9m to 47.6 diaphragm section. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

East Tower Lift #2:-Caltrans QA Inspector observed a welder performed FCAW repair process on inner corner

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

longitudinal seam weld that connected skin plate C and D. The FCAW repair weld area have been repair by ZPMC UT test and located at elevation 59m to 65m diaphragm section. The FCAW repair welding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted within the report above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Pau,Wai	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer